

1.0 PURPOSE

The following procedure describes the materials used and the sequence of operation to follow for painting the UMM guide trunk.

2.0 REFERENCE DOCUMENTS

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| 7225793 | Faired Mast Structural Module |
| 7377692 | Faired Mast Structural Module |
| 7377698 | Faired Mast Structural Module |
| 7225799 | Faired Mast Structural Module |
| 7377672 | Faired Mast Structural Module |
| 7377680 | Faired Mast Structural Module |
| 7377715 | Faired Mast Structural Module |
| 7377706 | Faired Mast Structural Module |
| 7377804 | Removable Cable Protection |
| 7377805 | Removable Cable Protection |
| 7225905 | Removable Cable Protection |
| 7225904 | Removable Cable Protection |
| 7377794 | Removable Cable Protection |
| 7377795 | Removable Cable Protection |
| 7377610 | Removable Cable Protection |
| 7377611 | Removable Cable Protection |

All the removable metallic parts defined in assemblies 7225793, 7225799, 7377706, 7377692, 7377698, 7377672, 7377680 and 7377715.

3.0 MATERIALS USED

Products to use are listed here above:

- 3.1 Mil-P-24441 type IV epoxy paint, formula 150 green primer.
- 3.2 Mil-P-24441 type IV epoxy paint, formula 152 white midcoat.
- 3.3 Mil-P-24441 type IV epoxy paint, formula 151 grey topcoat.

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- 4.0 SEQUENCE OF OPERATIONS AND PAINTING PROCEDURE FOR THE GUIDE TRUNK.
- 4.1 Perform all mechanical machining on the Guide Trunk, except for:
- finishing of the rails;
 - drilling for bolts and pins;
 - all external plates which are mounting surfaces;
 - the top and bottom surfaces.
- 4.2 Before sandblasting eliminate visible deposits of oil and/or weld spatter. Protect all the mating surfaces and rails.
- 4.3 Perform blast cleaning with quartz sand to achieve surface condition equivalent to Steel Structures Painting Council SSPC-SP 10/NACE No. 2 (Near-White Blast Cleaning).
- At the end of the sandblasting procedure, check the roughness and certify that a superficial roughness of $Ra > 2.3\mu m$ has been achieved on the surfaces.
- Sandblasting must be performed according to the following procedure:
- 4.3.1 Siliceous sand no. 3;
- 4.3.2 Nozzle type: 7 ½
- 4.3.3 Pressure: 6 atm
- 4.3.4 Distance between nozzle and parts to sandblast: 400 – 500 mm;
- 4.3.5 Passages number: 1.
- 4.4 After sandblasting, remove quartz sand with fiber brush.
- 4.5 Start the painting cycle within 3 hours from the end of the sandblasting cycle.
- 4.6 The painting cycle requires the following sequence.
- 4.6.1 Exclude from painting all the surfaces listed below:
- bearing rails
 - holes for bolts and pins
 - external plates which are mounting surfaces
 - top and bottom surfaces

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4.6.2

First coat.

Paint MIL-P-24441 type IV epoxy paint, formula 150 green primer.

Colour: Green

Dry thickness: 100 µm

Wet thickness: 150-175 µm

Application method: Airless spray

Wait 24 hours before applying the following coat.

4.6.3

Second coat.

Paint MIL-P-24441 type IV epoxy paint, formula 152 white midcoat.

Colour: White

Dry thickness: 100 µm

Wet thickness: 150-175 µm

Application method: Airless spray.

Wait 24 hours before applying the following coat.

4.6.4

Third coat:

Paint MIL-P-24441 type IV epoxy paint, formula 151 gray top coat

Colour: Gray

Dry thickness: 100 µm

Wet thickness: 150-175 µm

Application method: Airless spray.

4.7

After the last coat, cure for 24 hours.

4.8

Finish the mechanical machining excluded at paragraph 4.1.

4.9

Coat surfaces to be mated with a thin layer of MIL-G-24139 (NATO G-450) grease. Perform assembly.

4.10

As soon as the assembling process has been completed, perform a careful washing with detergents and degreasers in order to eliminate evident traces of grease on those surfaces which need to be retouched or painted. Retouch the surfaces.

5.0

SEQUENCE OF PAINTING OPERATIONS OF THE REMOVABLE METALLIC PARTS OF THE GUIDE TRUNK

5.1

Before sandblasting, eliminate visible deposits of oil and/or grease and weld spatter.

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- 5.2 Perform sandblasting in accordance with method specified in paragraph 4.3.
- 5.3 After the sandblast remove the quartz sand with fiber brush.
- 5.4 Start the painting cycle within 3 hours from the end of the sandblasting cycle.
- 5.5 Perform the painting cycle described in paragraph 4.6.
- 5.6 After the last coat, cure for 24 hours.
- 6.0 GENERAL CHECKS
- 6.1 Roughness Checks
- Measure the roughness of sandblasted surfaces. The roughness Ra shall never be less than the value indicated in paragraph 4.3.
- 6.2 Total Thickness Check
- Measure the total thickness of the dry film. The total thickness shall never be less than indicated in paragraph 4.6 (300mm).

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